

Work Order ID 80697

Wednesday, March 21, 2012 11:33:26 AM

80697

DUPLICATE

Page 1

Item ID: D4092-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Maintenance Step Assembly

Stop ***NS2***

Start Date: 2/27/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals:

Process Plan: *NR*

Date: *2-03-21*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4092	B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

8-2/23/21 (2)

8-2/23/21 (2)

8-2/23/22

(12)

all

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Page 2

Item ID: D4092-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Maintenance Step Assembly

Stop ***NS2***

Start Date: 2/27/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

12/3/22 SP

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/3/22 DJ

MK
12-03-22

Picklist Print

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Page 1

Work Order ID: 80697

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 2/27/2012

Required Date: 3/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No			100	Each	8.0000	2	4		2/23/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		7							
				77852		1							
				80564		6				4			
				ST241A		1							
				74303		1							
D4093-1 Bracket		Manufactured	No			100	Each	9.0000	1	2		2/23/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST195		9							
				78911		9				2			
D4093-3 Bracket		Manufactured	No			100	Each	23.0000	1	2		2/23/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST195		23							
				77850		3				2			
				80084		20							
D4093-5 Bracket		Manufactured	No			100	Each	18.0000	2	4		2/23/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST124		18							
				80085		2							
				80226		16				4			

Picklist Print

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Work Order ID: 80697

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 2/27/2012

Required Date: 3/12/2012

Start Qty: 2.00

Required Qty: 2.00

MS24694-S54

Purchased

No

100

Each

112.0000

2

4

Screw

Location

Loc Qty

Loc Code

ST289A

112

120142

12

120361

100

MS24694-S55

Purchased

No

100

Each

183.0000

8

16

Screw

Location

Loc Qty

Loc Code

ST289A

183

119307

33

120833

50

120910

100

MS24694-S56

Purchased

No

100

Each

69.0000

2

4

SCREW

Location

Loc Qty

Loc Code

ST289A

69

120142

44

120833

25

NAS1149D0332J

Purchased

No

100

Each

3,685.0000

12

24

Washer

Location

Loc Qty

Loc Code

ST298

3685

105793

12

110985

4

117087

89

119042

38

119717

740

120644

802

121011

2000

24

Picklist Print

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Page 3

Work Order ID: 80697

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 2/27/2012

Required Date: 3/12/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

100

Each

2,959.0000

12

24

Nut

Location

Loc Qty

Loc Code

ST300

2959

117441

16

117885

32

118451

5

118927

3

119017

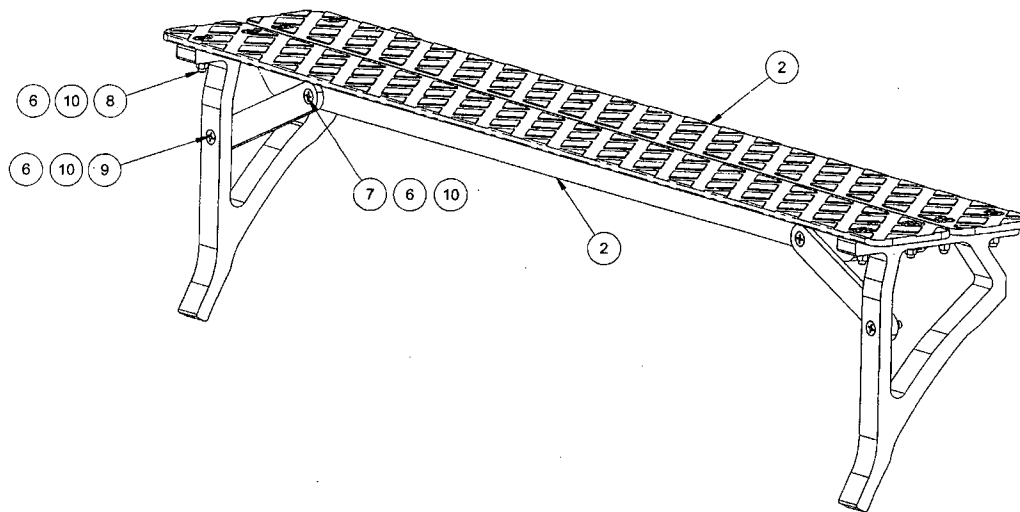
2730

119075

173

24

EP 12/03/12



D4092-041 MAINTENANCE STEP ASSEMBLY

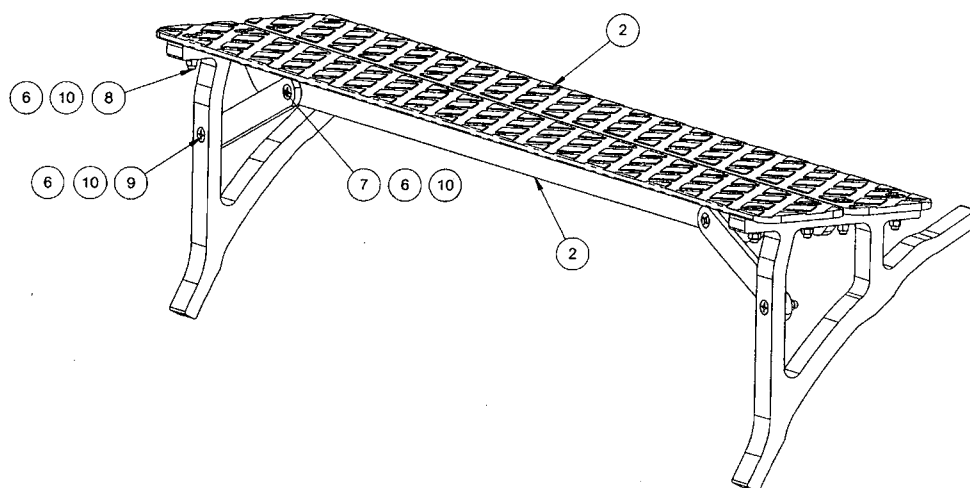


ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S66	SCREW
10	12	NAS1149D0332J	WASHER

#80697

RELEASED
2011-09-22
JW

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 1 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASSY	NTS
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D4092-042 MAINTENANCE STEP ASSEMBLY

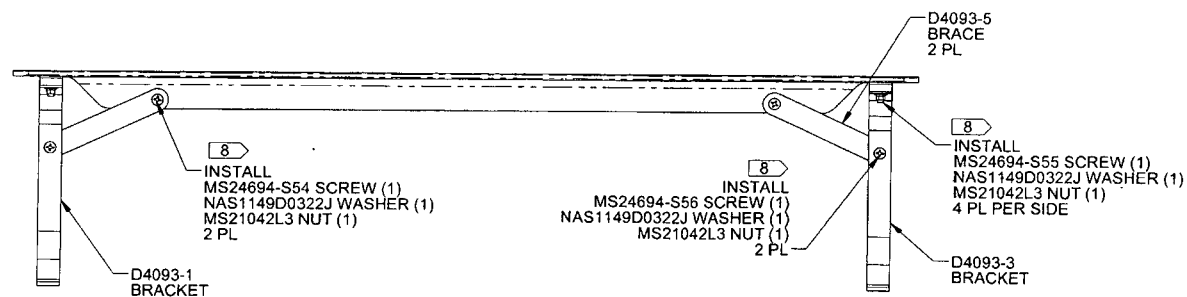
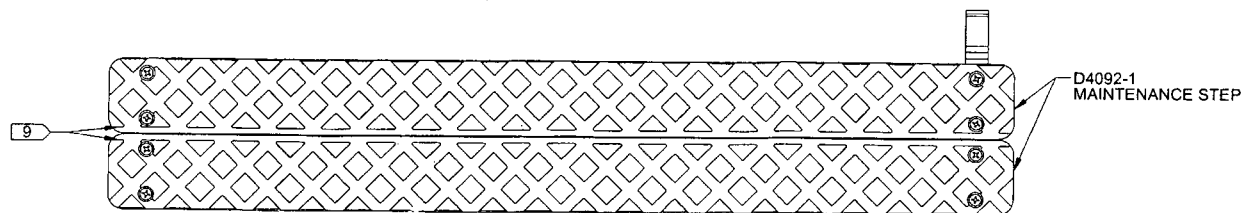


ITEM	QTY	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

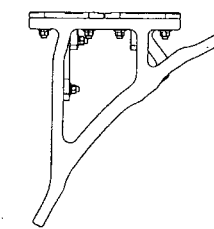
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#80697



RELEASED
2011-09-22

D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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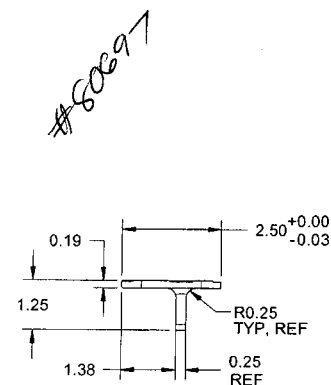
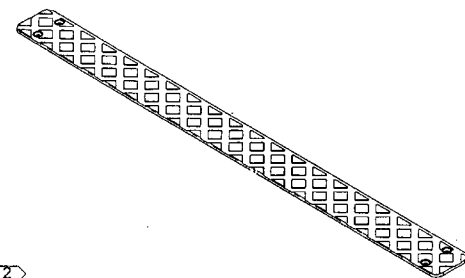
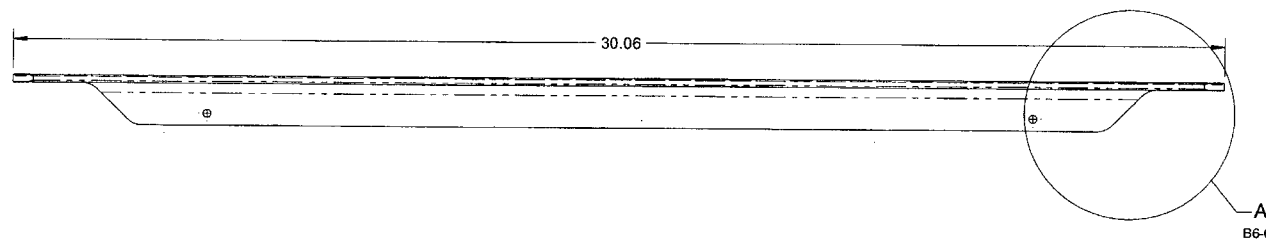
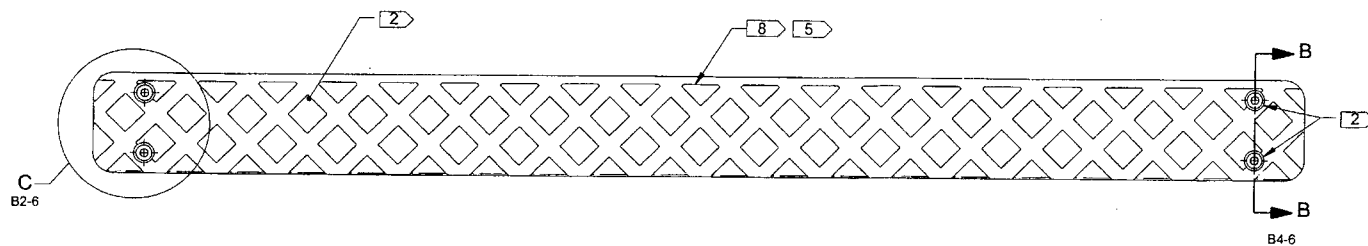
8 7 6 5 4 3 2 1

D

C

B

A



D4092-1 MAINTENANCE STEP (MAKE FROM D2761 EXTRUSION)

RELEASED
2011-09-22
JW

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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8 7 6 5 4 3 2 1



RELEASE
2011-09-22

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MFG. APPR.	<i>RF</i>	D4092	SHEET 6 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
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